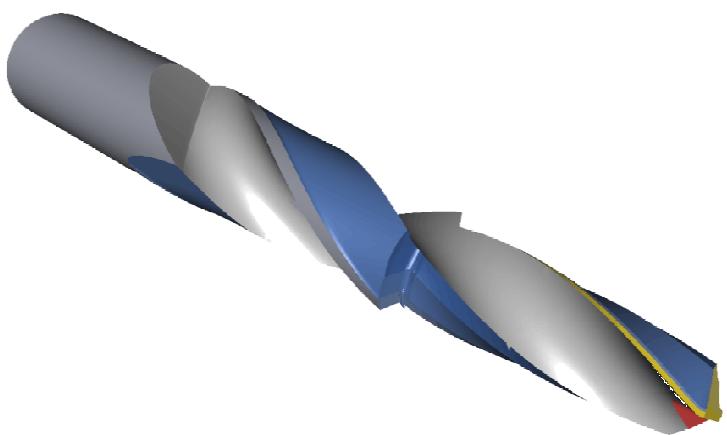


Profiled Step Drill Ø12 Ø8

A02-001

The Profiled Step Drill was ground from solid blank Ø12mm.



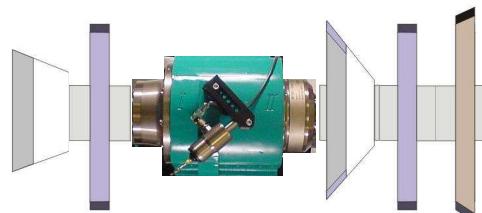
1. Cycletime for Production

Workpiece:	Diameter 12 mm, Z 2, Length of cutting edge 54 mm, Helix angle 30° Material CARBIDE									
Operations	Probe	Flute 1	Gashing	O.D.2	End 2	End 1	Prf Pgrd	Prf fin	Prf Cyl	Spanbrecher
Feed [mm/Min]	2000	60	80	125	50	70	50	70	10	70
Power [kW]		3	2	1	1	1	1	1	1	1
Cutting speed [m/s]		19	22	22	22	22	22	22	22	22
Used wheels		1	2	1	3	4	4	4	5	2
Grinding time [s]	9	168	33	72	34	27	322	236	213	122
Total cycle time	20 Min 36									

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø100 D64
4	1V1 Ø125 D64
5	1A1 Ø125 D64



3 5

2 1 4

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories: AWL 8

Responsible engineer: OP. 16.11.12

www.schneeberger.ch

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